

Work Order ID 79591***79591***

Page 2

January-30-12 7:00:07 AM

Item ID: D3676-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bubble Window

Start Date: 1/30/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

1) Check Surface finish for undesired marks, voids, dimples etc.2) Check depth of bubble to ensure conformity to drawing tolerances.

x/

G/L

12/02/01

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

x/

B

12/02/01

150

HAND FINISHING THERMOFORMING

0.00

150

Thermoform

Memo

0.00

Thermoforming Machine

1) Trim off excess flange material2) Buff out any light scratches or blemishes3) Etch part number and batch number

x/

G/L

12/02/01

Work Order ID 79591

79591

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January-30-12 7:00:07 AM

Item ID: D3676-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bubble Window
 Start Date: 1/30/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/03/12 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				X(OK 12/02/01
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo 1) Visually inspect for clarity, and proper formation.	0.00 0.00		8126261		(X)			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: REF LAB Memo	0.00 0.00							OK 12/02/01

PPP 80378 C12/3/9 ①

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January-30-12 7:00:07 AM

Item ID: D3676-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bubble Window
Start Date: 1/30/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/03/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/06 *[Signature]*

R12-024

Picklist Print

January-30-12 7:00:07 AM

Page 1

Work Order ID: 79591

Parent Item: D3676-1

Parent Item Name: Bubble Window

Start Date: 1/30/12

Required Date: 2/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Product 01/24/2008 DL Verified:JLM
IPP Rev B Change Mat. to .236"" 08/29/2008 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No				sf	280.9870		13.006503			

Location

therm

119347

Loc Qty

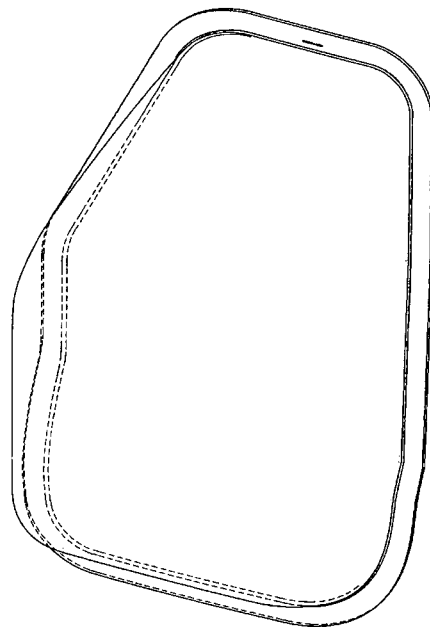
280.987

280.987

Loc Code

13.006503 sg ft.

17/02/01



D3676-1 412 BUBBLE WINDOW

who 79591

RELEASED
09/04/09 MW

NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,
0.236 THICK (STOCK REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3676-1" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE.
USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
- 7) WEIGHT: 11.0 lbs
- 8) VACUUM FORM PER FOLIO FTA018 USING DT8992 MOLD AND DART QSI 022

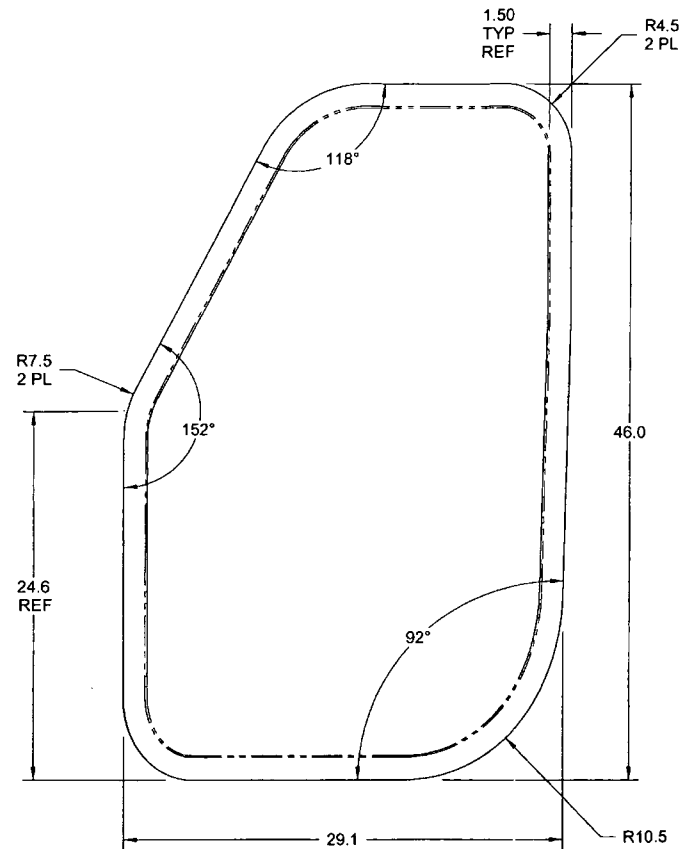
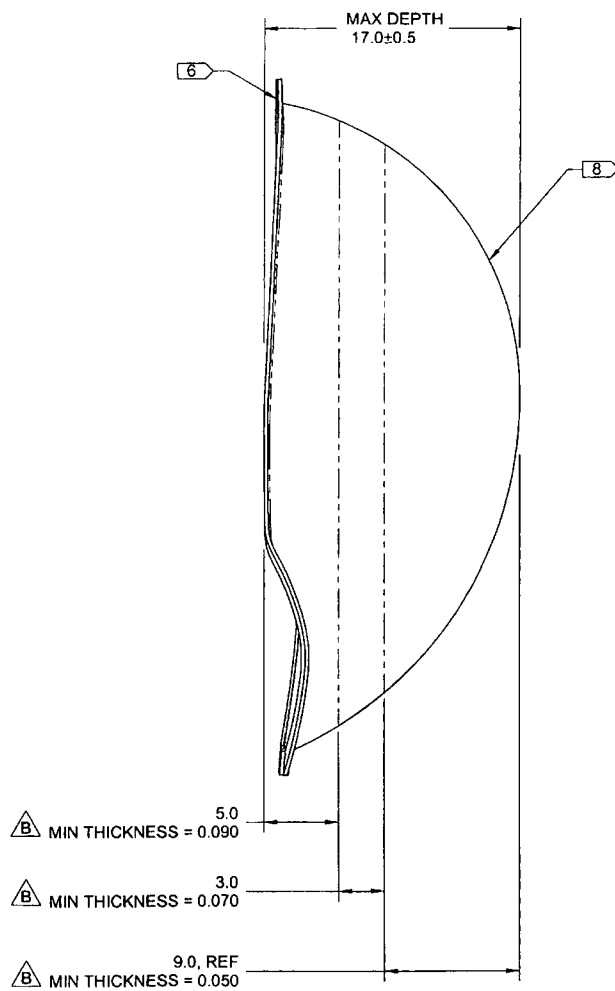
B	REVISED TOLERANCE ON MINIMUM THICKNESSES (ZN A8/B8-2) REASON: PRODUCTION FACILITY.	MB	08.10.27
A	NEW ISSUE	MB	08.02.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3676** REV. B
SHEET 1 OF 2

TITLE **412 BUBBLE WINDOW** SCALE NTS

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D3676-1 412 BUBBLE WINDOW

RELEASED
07/04/09

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3676	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		412 BUBBLE WINDOW	NTS
DATE	08.10.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD	Work Order: 79591
Description:	Part Number: D3676-1
Inspection Dwg: D3676 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>OK</u>	Date: <u>12/02/01</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.0"	± 0.100	46.0"	✓		TAPE DL-01	
29.1"	± 0.100	29.1"	✓		TAPE DL-01	
1.5"	± 0.100	1.5"	✓		TAPE DL-01	
0.090"	MIN	0.098"	✓		ULTRA	
0.070"	MIN	0.093"	✓		ULTRA	
0.050"	MIN	0.070"	✓		ULTRA	
17.0"	± 0.50	16.75"	✓		TAPE DL-01	

Measured by: <u>OK</u>	Date: <u>12/02/01</u>
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Audited by: <u>S</u>	Date: <u>12/02/01</u>
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14